Date: Tuesday, 9/4/2007 11:30:05 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: SHUT-OFF VALVE SHAFT
Job Number	: 34410		
Estimate Number	: 12170		
P.O. Number	: N/A	**Part Number**	: D34703
This Issue	: 9/4/2007 **S.O. No.** : N/A	**Drawing Number**	: D3470 REV.A
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : PURCHASED PARTS	**Drawing Revision**	: A
Previous Run	: 26115	**Material**	: N/A
Written By	:	**Due Date**	: 10/4/2007 **Qty:** 6 **Um:** Each
Checked & Approved By	: 07.09.04		
Comment	: est rev A 06.04.20 new issue EC		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M304S13GA	304/316 .090" Sheet
	Comment: Qty.: 0.0079 sf(s)/Unit Total : 0.0473 sf(s) 304/316 .090" Sheet M103033 HB 07-09-11	
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET Cut as per Dwg D Dwg Rev: A Prog Rev: A HB 07-09-11 (8)	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE HB 07-09-11	
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK counts Er 07/09/11 (x8)	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary. SAP 07/09/16 (8)	
6.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP counts Er 07/09/17 (x8)	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes (No) **DQA:** D **Date:** 9/05/18

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Tuesday, 9/4/2007 11:30:05 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** SHUT-OFF VALVE SHAFT

Job Number: 34410 **Part Number:** D34703

Job Number:

Seq. #:	Machine Or Operation:	Description :
7.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location:_____ 07/09/17 (8)

8.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE 07/09/18 (8)

Job Completion 07/09/17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

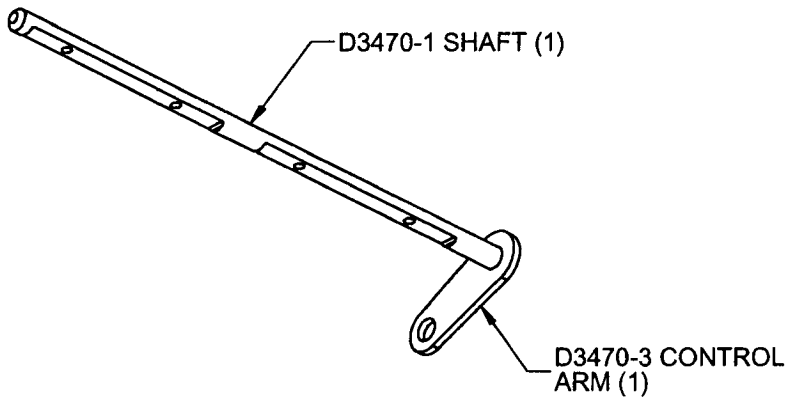
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

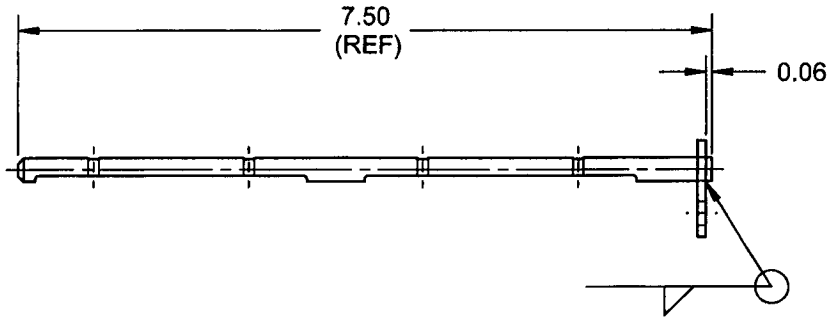
QA: N/C Closed: _____ **Date:** _____

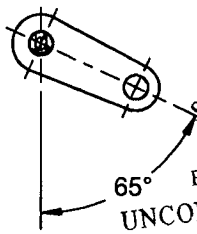
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3470	REV. A SHEET 1 OF 4
DATE 05.12.14		TITLE SHUT-OFF VALVE SHAFT	SCALE 1:2
A	05.12.14	NEW ISSUE	







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WORK ORDER
NO. B4410
06.04.03

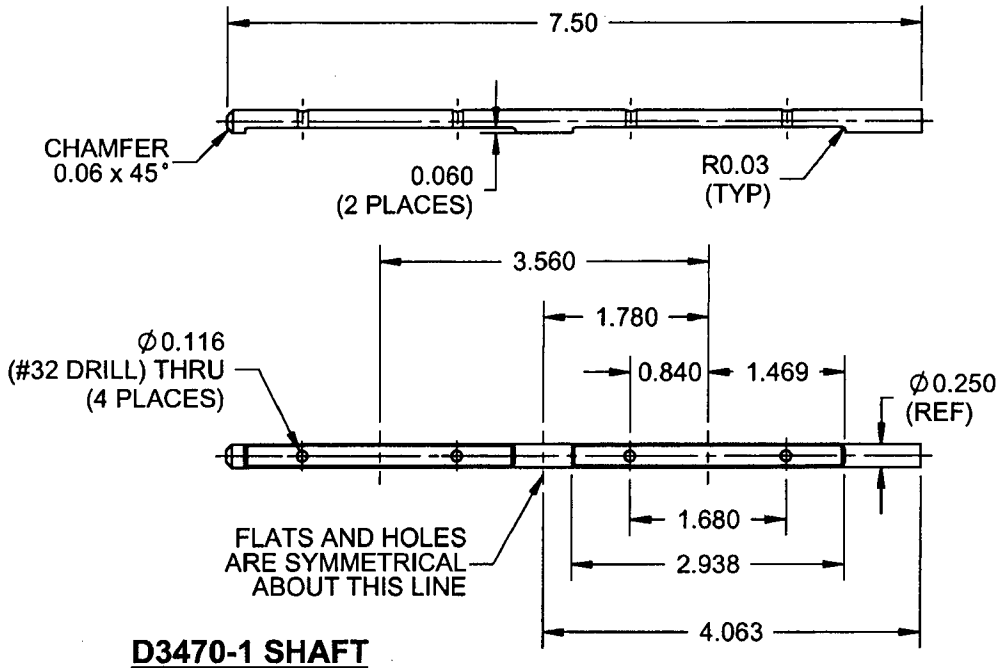
D3470-041 SHUT-OFF VALVE SHAFT

NOTES:

1) WELD PER DART QSI 004
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

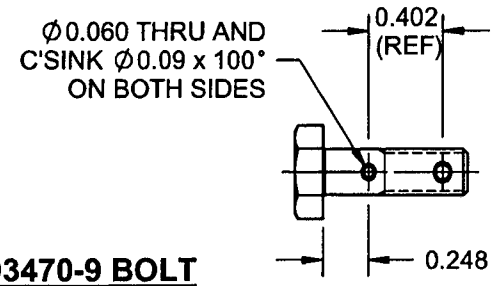
QTY -041	P/N	DESCRIPTION
X	D3470-041	SHUT-OFF VALVE SHAFT
1	D3470-1	SHAFT
1	D3470-3	CONTROL ARM

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3470	REV. A SHEET 2 OF 4
DATE 05.12.14		TITLE SHUT-OFF VALVE SHAFT	SCALE 1:2



D3470-1 SHAFT

1) MATERIAL: AISI 303 STAINLESS STEEL 0.25 ROUND BAR
(REF. DART SPEC. M303R0.250)



D3470-9 BOLT

SCALE 1 : 1

1) MAKE FROM AN4-6 BOLT

NOTES:

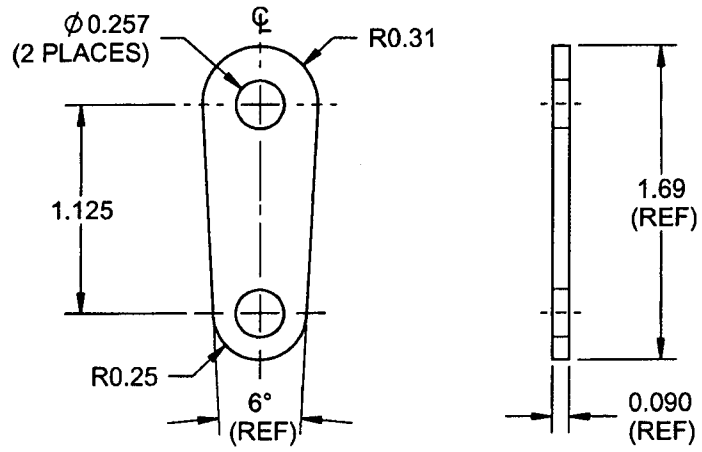
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3470	REV. A SHEET 3 OF 4
DATE 05.12.14		TITLE SHUT-OFF VALVE SHAFT	SCALE 1:1

16.04.03

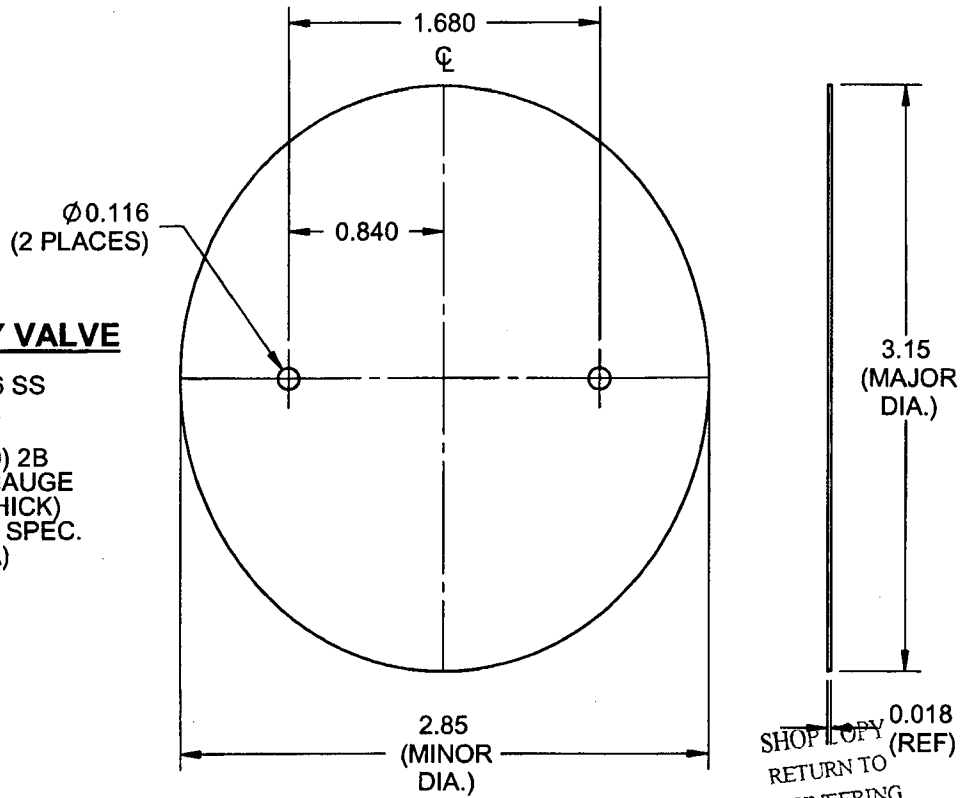
D3470-3 CONTROL ARM

1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 13 GAUGE SS (0.090 THICK) (REF. DART SPEC. M304S13GA)



D3470-5 BUTTERFLY VALVE

1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)



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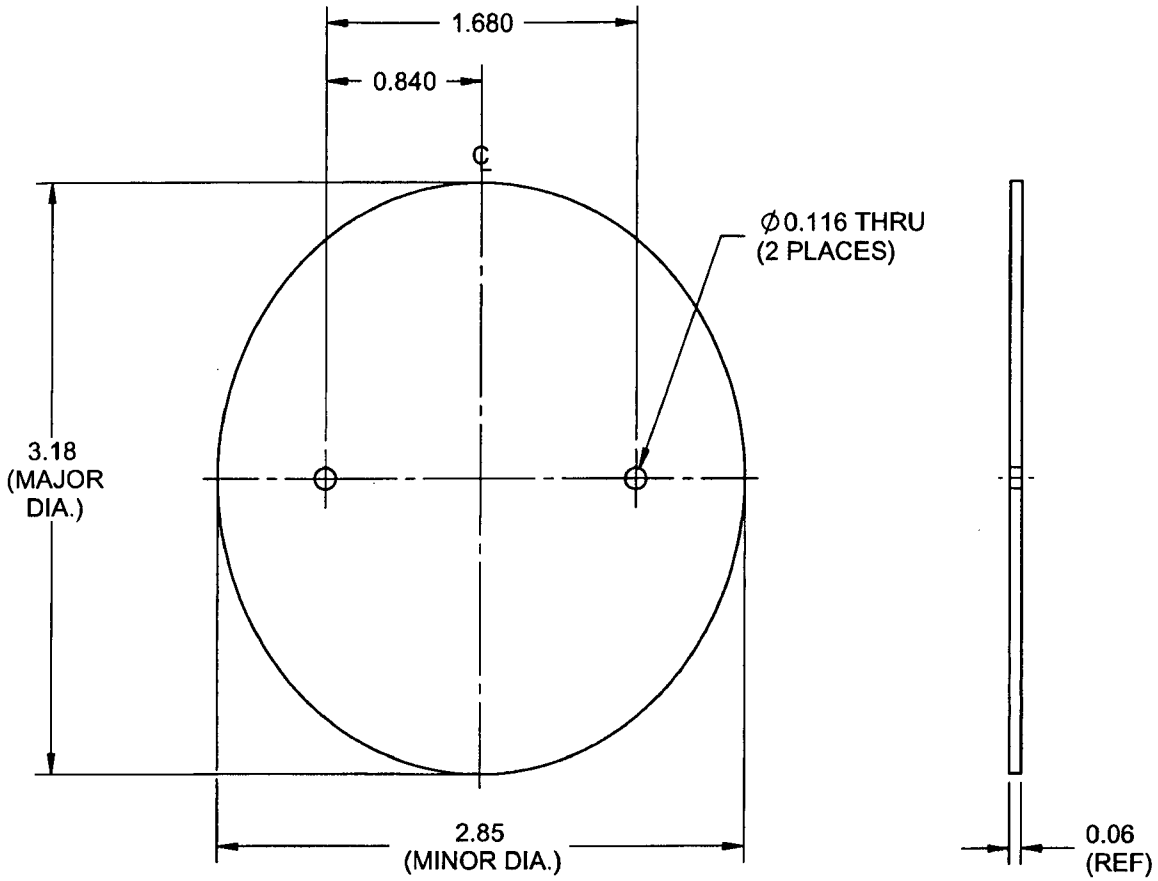
WORK ORDER NO. 34410

NOTES:

2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3470	REV. A SHEET 4 OF 4
DATE 05.12.14		TITLE SHUT-OFF VALVE SHAFT	SCALE 1:1



RELEASED
06.04.03

D3470-7 BUTTERFLY VALVE SEAL

NOTES:

1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, 0.063 THICK (REF. DART SPEC. M-SIL60-S.063)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WORK ORDER
NO. 34410

DART AEROSPACE LTD	Work Order:	34410
Description: SHUT OFF VALVE SHAFT	Part Number:	D3470-3
Inspection Dwg: D3470 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R .31	+/- .030	.31	X			
R .25	+/- .030	.25	X			
Ø .257	+.006 -.001	.259	X			
1.125	+/- .010	1.125				

Measured by:	LR
Date:	07-09-11

Audited by:	[illegible]
Date:	07/09/11

Prototype Approval:	N/A
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	